

Amendments to the Specification:

Please amend t paragraph 0025 as shown below:

[0025]

With reference to Figures 1a and 1b, a schematic of the apparatus for forming a spray-formed article is provided. Spray-form apparatus 2 includes indexing table 4 upon which mold 6 is placed. Mold 6 is the inverse of the spray-formed article to be formed. In a variation, mold 6 may correspond to the positive of an article, in which case, the metal part is not removed from the mold. Typically, mold 6 is made of a ceramic material and formed by pouring a ceramic slurry onto a master model that is solidified to form a ceramic pattern (i.e., the mold). Preferably, indexing table 4 is a rotatable table that is capable of being rotated in discrete increments in direction 8. Moreover, table 4 is translatable along direction 9, direction 10 and direction 11. Preferably direction 9, direction 10 and direction 11 are perpendicular to each other. Finally, table 4 and mold 6 may be tipped at an angle relative to the normal to the ground. Spray-form apparatus 2 further includes spray station 12 with thermal spray guns 14, 16, 18 mounted on spray gun holder 20. If needed, additional spray stations are added to the apparatus of the present invention. Preferably, the apparatus of the present invention includes from 1 to 5 spray stations. More preferably, the apparatus of the present invention includes 1 to 3 spray stations, and most preferably two spray stations. Furthermore, each spray station can hold one or more spray guns only limited by the space that each such spray gun occupies. Preferably, each spray station will have three spray guns. During operation, consumable metal wires 22, 24 are fed into spray guns 14, 16, 18 where they are melted by an electric arc. High velocity gas is also fed into spray guns 14, 16, 18 through manifold 26 causing the melted metal to form metal spray 28 that is directed toward mold 6 which is subsequently coated with a metal coating. Although a single spray gun may melt any number of consumable wires, preferably two consumable wires are melted with the electric arc.

Please amend t paragraph 0034 as shown below:

[0034]

In another embodiment of the present invention, a method of making a spray-formed article using the spray-form apparatus of the present invention is provided. The method of this embodiment comprises:

- a) providing a mold that is the inverse of the article, the mold having an exposed surface to be coated by a metallic spray;
- b) placing the mold on an indexing table that is rotatable in increments between 0 and 360 degrees;
- c) directing the metallic spray onto a first portion of the mold;
- d) rotating the mold by a discrete angular increment; and
- e) directing the metallic spray onto an adjacent portion of the ceramic mold;
- f) repeating steps d) and e) until a metal-coated mold is formed wherein a substantial portion of the surface of the mold has been coated with the metal spray and the metal-coated mold comprises a metal layer over the mold. Typically, the metal spray is a hot metal spray. Each rotation of the mold exposes a portion of the mold adjacent to that portion which has just been coated. This newly exposed adjacent portion is then coated by the metal spray. In some variations, the metallic spray is stopped during each rotation of the mold. Furthermore, it is understood that these adjacent portions will overlap to some extent. The method of this embodiment further comprises:

- g) allowing the metal-coated mold to cool; and
- h) separating the metal layer and the mold to provide the article.

Please amend t paragraph 0039 as shown below:

[0039]

According to the method of the present invention, the metal spray is formed by melting one or more consumable wires with an electric arc to form molten metal and atomizing the molten metal with a high velocity gas jet. Although a single spray nozzle may melt any number of consumable wires, preferably two consumable wires are melted with the electric arc. The

method of the present invention is further characterized such that the metal spray may either be stopped or not stopped during each rotation of the mold. Typically, the metal spray is not stopped during each rotation of the mold. When spraying is not stopped during rotation, the angular velocity is sufficiently high that less than about 10% of the coating formed by the metal ~~spray-forms~~ spray forms during rotation.